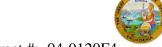
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-005062 Address: 333 Burma Road **Date Inspected:** 22-Nov-2008

City: Oakland, CA 94607

OSM Arrival Time: 2300 **Project Name:** SAS Superstructure **OSM Departure Time:** 730 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Li Yan Hua **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** PMT - deck panels

Summary of Items Observed:

Sub-assembly – Bay 1 - PMT

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) monitored OBG Production Monitoring Test (PMT) #1 for deck panels DP419-001 and DP446-001 at Gantry #1. Prior to PMT #1, the magnetic particle test (MT) of the tack welds was noted on the test panel as having been performed by ZPMC MT Inspector Zhou Dong Yun. The visual inspection of tack welds and root gap was performed by ABF QC Wang Zhen Hua (ABF), ZPMC CWI Li Yan Hua (CWI), and QA Inspector. The start time for welding of PMT #1 was approximately 0031 hours on Sunday, 11/23/08. QA inspector randomly verified and documented the welding amperage, voltage and travel speed during the gas metal arc welding (GMAW) and submerged arc welding (SAW) processes, welds 1 thru 6 at the completion of both the GMAW root pass and SAW cover pass. The start of the SAW process was delayed because welding machine #4 shut down approximately 30mm into the weld the first time and approximately 10mm into the weld the second time. ZPMC workers remedied the problem with the welding machine and the test was completed without further incident. The welds were visually inspected by ABF, CWI and QA Inspector. QA inspector witnessed ZPMC Ultrasonic Testing (UT) inspector, identified as Ma Ji Long, perform UT on each of the welds for depth of penetration and conformance. QA inspector identified designated locations for macroetch sampling per contract requirements. The macroetch specimens were evaluated with a 7X optical comparator and a 10X optical comparator and accepted by CWI, ABF, and QA Inspector. All fifteen sample macros appeared to meet requirements and were noted to appear acceptable. See Caltrans U-ribs PMT Inspection Sheet, ZPMC production monitoring test plate inspection report, and Caltrans Macro Etch Log - all dated 11/23/2008 for additional information.

Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

No significant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, 150-0219-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer